

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029380**Date Inspected:** 21-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** S.A.S. Job site**CWI Name:** N / A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Structure**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI continued reviewing the contractor's submitted Electro-Slag Welding (ESW) reports and referencing the Requests for Weld Repair (RWRs) in order to determine the status of completion of the repairs and welds' overall reported condition. The QAI completed reviewing welding report package submittal 1536R148, 149 and 150. The QAI noted that during the document reviews, previously submitted welding inspection and testing reports are being identified as needing corrections / revisions. These reports are being copied / noted and will be provided to the contractor for additional information. Reference the TL-20 reports for additional information. The QAI began reviewing additional welding report packages and submittals of welding reports. This work was in progress until the end of the shift.

The QAI performed an informational inspection of the zinc pads on a suspender rope brace. The QAI was provided 1 of the braces (w/ 8 total pads) and noted that several of the zinc pads appear to be cracking in locations where in contact with the suspender wires. The QAI noted that cracks are visible before and after wire brush cleaning of the part and also after liquid penetrant testing (PT). There were no PT indications that were not identified visually prior to the PT inspection. The back of the pads was not examined due to the mounting adhesive that is in place. The QAI noted that there are more cracks apparent along the back (outer curve) of the zinc pads. This information was relayed to the Structural Materials Representative Bahjat Dagher.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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### Summary of Conversations:

The QAI relayed the status of the document / submittal reviews and inspection of the zinc brace pads to the QAI Lead Danny Reyes. Except as described above, there were no other notable conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas, (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer

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